Work Order ID 98415 *98415* Page 1 March-12-13 1:54:38 PM D3255-2 Accept Item ID: *N900040100* Setup Start **Revision ID:** Stop Item Name: Panel **Start Date:** 3/11/13 Start Oty: 4.00 **Cust Item ID:** Required Date: 3/19/13 **Reg'd Oty: 4.00 Customer:** Reference: Start Run Process Plan: ML 5 Date: 13-03-13 Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Set Up/ Tool # Plan Reject Reject Sequence ID/ **Operation** Tool ID Accept Insp. Description Number Stamp Work Center ID **Run Hours** Code Qty **Qty** Draw Nbr **Revision Nbr** D3255 Rev B 100 0.00 FLOW WATER JET *100* Waterjet 0.00 Memo B Prog Rev: 3 FLOW CNC Waterjet 1-Cut as per Dwg D3255 Dwg Rev: Deburr if necessary 304.052 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* QC 0.00 Memo Quality Control

120

QC8- Inspect parts - second check

120

Quality Control

OC

Memo

				DQA:	Date:	
NCR:	Yes	/ No	WORK ORDER NON-CONFORMANCE / UPDATE		, ,	

								<u> </u>		QA Closed:	Date:	
Work Order	֥				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part No					Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing		—	Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other
NCR N	o				Work Order Update]		Large Fab	Composite			
Root				Descri	ption of work order update	In	itial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
onapproved 1			<u> </u>		F	AULT	CATE	GORY				
Landin	g Gear				General							
	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspection Ripples in Torque W	Crimped at n Strip in ı Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		nstruct Mainte Mislabe Misreac Offset	on Incomplete ions Incomplete/ nance led	/Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	st ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Turning S	equence			Finish		Out of S	equence				
	Wave/Tw	ist in Tub	oe -		Folio	1 (Outside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde March-12-13 1:	and the second second	8415		*(Page 2							
Item ID: Revision ID:	D3255-2			Accept		N9NN	040	100)* s	etup Start	10'21		
Item Name:	Panel		•			•				Stop	*N	S2*	
Start Date:	3/11/13	Start Qty: 4.00	*4*			Cust Item 1	ID:						
Required Date: Reference:	3/19/13	Req'd Qty: 4.00	*4*			Customer:				. •			
Approvals:	Process P	lan:	Date:	Tooling:	<u> </u>	D	ate:		R	un Start	VI.	R1*	
	QC:		Date:	SPC (Y/	N):	. D	ate:			Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description			p/ Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	50 13/08
130		NC BRAKE		0.00					W		F	F	
130 Brake NC		Memo		0.00								3-04-16	>
Brake NC		Form as per	Dwg D3255		27 27							. •	ì
140		QC5- Inspect part comple	eteness to step on W/O	0.00					7.1	,			
*14 0 *		Memo		0.00	134,11				7				
Quality Control		Mento											
150		Identify as per dwg & Sto	ock Location:	0.00			·	:	Ü			12~	-NU-i N
150 Packaging	• .	Memo		0.00					7			· /ɔ ·	04-17

Packaging

										DQA:	Date:		
NCR: Y	es / No				WORK ORDER NON-	-COI	VFOR	MANCE / UPDA	ATE				
										QA Closed:	Date:		
Work Orde	r:				DISPOSITION				AGAINST DEPARTMENT/PROCESS				
Part No					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			ł	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root	1	T		Descr	iption of work order update	T	nitial	Action	n	Sign &			
Cause	Date	Step	Qty		or Non-conformance		ief Eng	Descript		Date	Verification	QC Inspector	
quip/Tooling Operator Material etup Other Process upplier Fraining													
		1	<u> </u>			FAUL	T CATE	GORY		<u> </u>		- 1 -	
Landin	g Gear				General							1	
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset			Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
Ĺ	Torque	Waves in I	Extrusion	۱ ل	Drawing		Out of 0	Calibration					
1	Turning	Sequence	,	1	Finish	ı	Out of	Sequence					

Outside Dimensions

Wave/Twist in Tube

Folio

Work Ord March-12-13		8415		*984		Page 3				
Item ID: Revision ID: Item Name:	D3255-2			Accept	*N900	<u>04010</u> 0) *	Setup Start Stop	*NS1* *NS2*	
Start Date: Required Date Reference:	3/11/13 2: 3/19/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item II Customer:) :		Run Start		
Approvals:	Process P	lan:	Date:	Tooling: SPC (Y/N):	Da		ı	Run Start Stop	*NR1* *NR2*	
Sequence ID/ Work Center	ID	Operation Description QC21- Final Inspection	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code	Accept Qty		Reject Insp. Number Stamp	
160 QC Quality Control		Memo		0.00				17171	1	
								pl	13041)	

			DQA:	Date: _	
NCR: Yes	/ No	WORK ORDER NON-CONFORMANCE / UP	PDATE		

									QA Closed:	Da	te:	
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS		
Part N	lo				Rework Scrap Use-as-is Work Order Update	The	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet Enginee Prod. Eng. Coor. Qu Rec/Store/Packaging O Supplier		
Root				Descr	iption of work order update	Initial	A	ction	Sign &			
Cause	Da	ite Step	Qty		or Non-conformance	Chief En	g Des	cription	Date	Verification	n QC Inspector	
Doc/Data												
Equip/Tooling			-			İ				ļ		
Operator												
Material			1									
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Other												
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Unapproved					·		<u> </u>					
					F.	AULT CAT	EGORY					
Landi	ng Gear			_	General				٦	,		
	Bend	ling			Bend	Grain	1		Ovalized	ļ	Pressure/Forced	
		re Not Cond	entric to	O/S	BOM/Route	Hard			Over/Under		Temperature/Cure	
	Crac				Broken/Damaged	—	ction Incomplete		Part Incorre	1	Weld	
	-	hed/Crimpe	d		Burrs	\vdash	ctions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
	Cuff	5			Contamination	-	tenance		Part Moved			
	Heat	Treat		_	Countersink	Misla	beled		Positioned V	- 1		
	Insp	ection Strip	in Tube	<u></u>	Cut Too Short	Misre	ad		Power Loss/	Surge	Other	
	Ripp	les in Bend		1	Drill Holes	Offse	t					
	Torq	ue Waves ir	n Extrusio	n L	Drawing	—	f Calibration					
	Turn	ing Sequen	ce		Finish	Out o	f Sequence					
	1 11/21	a/Twist in T	uho		Folio	I Inutei	da Dimansions					

Picklist Print

March-12-13 1:54:38 PM

Work Order ID:

98415

Parent Item:

D3255-2

Parent Item Name:

Panel

Start Date: 3/11/13

Required Date: 3/19/13

Page 1

Start Qty: 4.00

(21889

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-08-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA 304/316 .032 Sheet		Purchased	No			100	sf	221.2600	1.484	6.24 8421 2			Jm13-4-9
304/310 .032 Silect				Location		Loc Qty	<u>L</u> c	oc Code	-			<u> </u>	
				MAT020		221.26							
				11827	71	10.76							
				12086	66	55.6							

121889

154.9

DQA:	Date:	

WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Y	'es /	No				WORK ORDER NON-C	CONF	ORI	MANCE / UP	DATE	QA Closed:	Da	te:	
Work Orde						DISPOSITION	T			AGAINST DE				
Part N						Rework Scrap Use-as-is Work Order Update	Machining Small Fa Thermoforming Finishin			Crosstube Small Fab Finishing Composite	b Prod. Eng. Coor. Q g Rec/Store/Packaging 0			
- Ten	···—						compos				Ste			
Root						ption of work order update	Init			tion	Sign &			
Cause	C	ate	Step	Qty	(or Non-conformance	Chief	f Eng	Desc	ription	Date	Verificatio	n QC Inspect	tor
Doc/Data		l												
Equip/Tooling				,			1							
Operator														
Material		- 1												
Setup									,			<u> </u>		
Other	_													
Process	Щ	ĺ		·	į							l		
Supplier	Ц													
Training	Щ													
Unapproved														
							AULT (CATE	GORY					_
Landir	ng Geai				_	General					1	ļ		
	_	nding			_	Bend	H _G	rain		<u> </u>	Ovalized		Pressure/Force	
	Cer	ntre Not	Concer	itric to	o/s	BOM/Route	<u> </u>	ardwa	_		Over/Under	i	Temperature/C	ure
	Cra	icks				Broken/Damaged	\vdash		on Incomplete		Part Incorre		Weld	
	Cru	ished/Cr	imped		<u> </u>	Burrs	_		ions Incomplete/	'Unclear	Part Lost/Mi	issing	Wrong Stock Pu	ılled
	Cut	ffs				Contamination	Шм	lainte	enance	<u> </u>	Part Moved			
	He	at Treat				Countersink	M	islabe	eled		Positioned V	_		
	lns	pection :	Strip in	Tube	L	Cut Too Short	М	isread	t		Power Loss/	'Surge	Other	
	Rip	ples in B	Bend			Drill Holes		ffset						
	Toı	que Wa	ves in E	xtrusio	n	Drawing		ut of 0	Calibration					
	Tui	rning Sec	quence			Finish		ut of S	Sequence					
	□\ _{\^/} -	wo/Twic	t in Tub			Folio		utside	Dimensions					

DART AEROSPACE LTD	Work Order:	98415
Description: Access Panel Assembly	Part Number:	D3255-2
Inspection Dwg: D3255 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prof	totype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.102	_		V	Jamos
15.171	+/-0.010	15.171°	_		T	Jemoi Jemou Prover
10.032	+/-0.010	10.032"	_ :		ν	Proxim
6.902	+/-0.010	6-902"	_		ν	
18.456	+/-0.010	18.456	_		Т	
11.432	+/-0.010	11. 432	_		V	
2:261	+/-0.010	2.265	-		V	
2.363	+/-0.010	2.364			V	
2.363	+/-0.010	2.365	_		V	
1.183	+/-0.010	1.184"	-		ν	
0.250	+/-0.010	0253~	_		ν	
0.250	+/-0.010	0,2537	_		V	
2.261	+/-0.010	2-260	_		V	
		,				
-						
			o A s			

Measured by: Jm Audited by: Prototype Approval: N/A

Date: 13-4-9

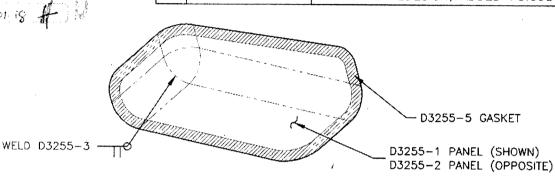
Date: 13-4-9

Date: N/A

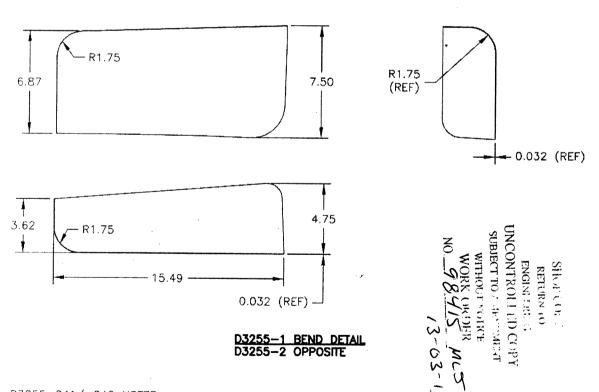
Rev	Date	Change	Revised by	Approved
Α	08.05.06	New Issue	KJ/DD ox	N.
			· · · · · · · · · · · · · · · · · · ·	



r			
DESIGN DRAWN BY			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED /	APPROVED	DRAWING NO. REV. B
	41	J 44-	D3255 SHEET 1 OF 4
DATE			TITLE SCALE
 04.1	2.06		ACCESS PANEL ASSEMBLY 1:6
Ą		04.01.27	NEW ISSUE
В		04.12.06	D3255-3 REDESIGN; ADDED Ø0.098



D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)



- D3255-041/-042 NOTES:
 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

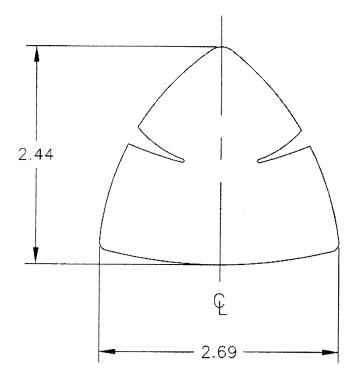
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DESIGN	DRAWN BY	1	ROSPACE LTD
CHECKED (APPROVED	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE		TITLE	SCALE
04.12.06		TITLE	1:1





<u>D3255-3 CAP</u> FORM TO FIT D3155-1/-2

D3255-3 NOTES:

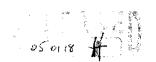
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

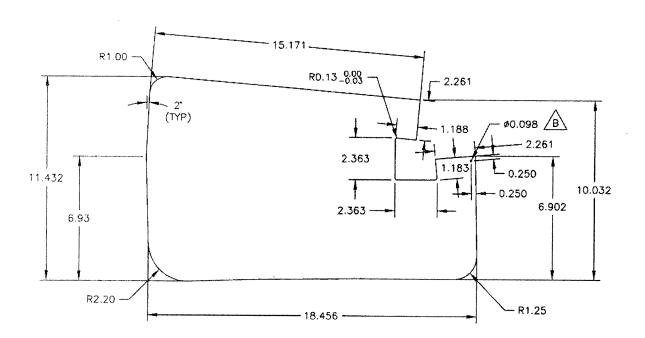
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECKED P	APPROVED	DRAWING NO. D3255	SHEET	REV. 3 OF	_
DATE		TITLE		SCA	LE
04.12.06		ACCESS PANEL ASSEMBLY		1	:5





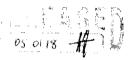
D3255-1/-2 FLAT PATTERN

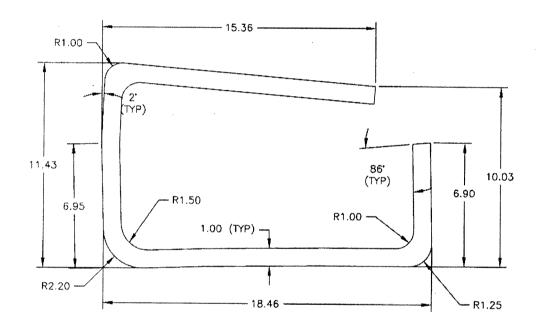
D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



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	4	THE STATE OF THE S	D3255	SHEET 4 OF 4
DA	TE		TITLE	SCALE
0	4.12.06		ACCESS PANEL ASSEMBLY	1:5





D3255-5 GASKET

- D3255-5 NOTES:
 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16

 POSSIBLE SUPPLER: AVIALL

 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

 3) ALL DIMENSIONS ARE IN INCHES